Work Order ID 96415 *96415* Page 1 January-28-13 10:43:40 AM Item ID: D3235-1 Accept *N900040100* Setup Start **Revision ID:** Mounting Lug Item Name: Start Date: 1/28/13 **Start Oty: 80.00 Cust Item ID:** Required Date: 2/22/13 Rea'd Otv: 80.00 **Customer:** Reference: Run Date: <u>13-01-28</u> Tooling: Approvals: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Code Oty **Qty** Number Stamp Draw Nbr **Revision Nbr** D3235 Rev A 100 0.00 **BAND SAW** *100* Bandsaw 0.00 Jeaspa Bandsaw Cut D2423 extrusion to 0.820" 110 0.00 1 po18984 P/13-01-30 C VERTICAL MACHINING #1 1-Machine as per Folio FA369 and Dwg D3235 UDDeel ? 10 to meter HAAS CNC vertical machine #1 2-Identify as D3235-1 muchineas par dug D 3235REJ. A 3-Deburr QG2-Inspect parts off machine-FAI/FAIB> 0.00 read + inspect
attached cof ctow/o 43/2/25

											DQA:	Dat	te: _	
NCR:	⁄es	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UPDATE		·		_	•
											QA Closed:	Dat	te:	
						DISPOSITION			AGAINS	T DE	PARTMENT,	PROCESS		
Work Orde	er: _	· · · · · · · · · · · · · · · · · · ·				D	1		Child Andre Comments	_ [1	Water Jet	_	Engineering
D 1						Rework	$\mid \cdot \mid$		Skid-tube Crosstub Machining Small Fa	-	D	d. Eng. Coor.	-	Engineering Quality
Part N	NO					Scrap	1		Machining Small Fa noforming Finishin	-	4	e/Packaging	\dashv	Other
NCR I	u.					Use-as-is Work Order Update	1		Large Fab Composit	~	Kec/3toi	Supplier	\dashv	
NCKI	1 0. –					Work Order opdate	J		composit	·]	Jupplier		
Root	\Box				Descri	ption of work order update		nitial	Action		Sign &		\Box	
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	Ш	Bending				Bend	$ldsymbol{ldsymbol{eta}}$	Grain			Ovalized		${f H}$	Pressure/Forced
	Ц	Centre No	ot Conce	ntric to (0/s	BOM/Route	_	Hardwa		<u> </u>	Over/Under		\vdash	Temperature/Cure
	Ц̈́	Cracks				Broken/Damaged		1	ion Incomplete	<u> </u>	Part Incorre		-	Weld
	Ц	Crushed/0	Crimped,			Burrs	_	Instruct	tions Incomplete/Unclear	L	Part Lost/M	issing		Wrong Stock Pulled
1	1 1	Cuffs				Contamination	1	Mainte	enance	- 1	Part Moved			•

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Powder Coating

Work Ord January-28-13				*9641	5*					Page 2
Item ID: Revision ID: Item Name:	D3235-1 Mounting Lug			Accept *	N9000	40100)* s	etup Star Stop	ı u.	31* 32*
Start Date: Required Date Reference:	1/28/13	Start Qty: 80.00 Req'd Qty: 80.00	*80* *80*		Cust Item ID: Customer:					
Approvals:		n:	Date:	Tooling:	Date:		R	un Star Stop	" \	₹1* ₹2*
Sequence ID/ Work Center 130 *130* QC Quality Control	ID ·	Operation Description QC - Inspect parts - seco	nd check	Set Up/ Run Hours 0.00 Sm () 0.00 /3.2.2.S		Fool # Plan Code	Accept Qty 100 Olund	Reject Qty	Reject Number	Insp. Stamp
*140 *140* HandFinish Hand Finishing		Chemical Conversion Co	at per QSI005 4.1	0.00			106) Pu	<u>613</u>	207
160 *160* Powdercoat		White Gloss(Ref: 4:3.5.1)	QSI005 4.3-Alum	0.00	·		160	þ	A E	3-2-28

NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE			4
	•								QA Closed:	Date:	
Work Orde	r:				DISPOSITION	_		AGAINST DE	PARTMENT		
Part N	0				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	-4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o			·····	Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		T
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling										·	
Operator						1					
Material											
Setup											
Other									Ì		
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Supplier											
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Landin	ig Gear				General				_	_	-
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to C	o/s	BOM/Route	Hardv	vare	L_	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instru	ctions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
ſ	Heat Trea	it			Countersink	Misla	oeled		Positioned \	Wrong	in the same of the
Ī	Inspection	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss,	/Surge	Other
Ţ	Ripples in	Bend			Drill Holes	Offset	t				
Ţ	Torque W	/aves in E	xtrusion	, [Drawing	Out o	f Calibration				
Ţ	Turning S				Finish	Out o	f Sequence				
Ţ	Wave/Tw	ist in Tul	эе		Folio	Outsi	de Dimensions				

Date:

DQA:

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ID 06415

Work Ord January-28-13				*964	15*						Page 3
Item ID: Revision ID: Item Name:	D3235-1 Mounting Li	ug		Accept	*N900	040	100)* s	etup Start Stop	*N: *N:	S1* S2*
Start Date: Required Date: Reference:	1/28/13	Start Qty: 80.00 Req'd Qty: 80.00	*80* *80*		Cust Item II Customer:	D:					
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ite:		R	un Start Stop	171	R1* R2*
Sequence ID/ Work Center I 170 *170* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty /O) COlon	Reject Qty	Reject Number	Insp. Stamp
*180 *180* Packaging Packaging		Identify as per dwg & Sto	STY70	0.00					/3/3	3/5	(100)
*190 *190* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					13/	3/5 me	3-5

NCR:	Yes	/	No
14011.	103	,	

												DQA:	Date	e: _						
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	AANCE / UP	DATE	QA Closed: Date:								
			·			1	DISPOSITION				AGAINST DE	***************************************								
Vork Ord	er: ˌ					١		,			_	1								
Part NCR							Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other					
Root				1	Desc	crip	otion of work order update		nitial	Ac	tion	Sign &		Т						
Cause		Date	Step	Qty		-	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification		QC Inspector					
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved									÷ 3											
							F.	AUL	T CATE	GORY		·								
Land	ing (1			г		General		1			٦	Г							
		Bending Centre No Cracks Crushed/			/S		Bend BOM/Route Broken/Damaged Burrs		1	re on Incomplete ions Incomplete/	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled					
		Cuffs Heat Trea		•			Contamination Countersink		Mainte Mislabe	nance		Part Moved Positioned V	_							
		Inspection	n Strip in	Tube	Ì		Cut Too Short		Misread	i		Power Loss/	Surge		Other					
		Ripples in	Bend				Drill Holes		Offset			- 								
		Torque W		Extrusion	ļ		Drawing		Out of	Calibration										
		Turning S	oauonco		1		Finish		Out of	Sequence										

Outside Dimensions

Wave/Twist in Tube

Folio

Picklist Print

January-28-13 10:43:40 AM

Work Order ID:

96415

Parent Item:

D3235-1

Parent Item Name:

Mounting Lug

Start Date: 1/28/13

Required Date: 2/22/13

Page 1

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP A04.04.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			110	f	753.5000	0.0683	_5.75157	EL131	01/3C)
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT006		417.5							
				4372	2	161.5							
				8795	3	256							
				Metec		336							
				9355	i	336			_ (<u>,, 83</u>	1)	
D3235-1P lug		Purchased	No			100	Each	0.0000	1	80	/2/	3/2/30	<u>r(/0</u>

										DQA:	Date	e:
NCR: Y	es / No				WORK ORDER NON-O	CONFO	⊃RIV	MANCE / UPDATE	,	QA Closed:	Date	
Work Orde	r·				DISPOSITION			AGA	AINST DEF	ARTMENT	PROCESS	
Part N	0				Rework Scrap Use-as-is Work Order Update] T1	M herm	Machining Sma oforming Fin	istube all Fab ishing posite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initi	al	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		1										
Operator												
Material [İ					
Setup												
Other							1					
Process												
Supplier							İ					
Training									į			
Unapproved												
						AULT C	ATEG	GORY				
Landin	g Gear				General						Г	
1	Bending			ļ	Bend	\vdash	ain			Ovalized		Pressure/Forced
1	Centre No	ot Conce	ntric to	o/s	BOM/Route	 	rdwar		 	Over/Under	-	Temperature/Cure
ļ	Cracks			<u> </u>	Broken/Damaged		•	on Incomplete	<u> </u>	Part Incorre	- t	Weld
	Crushed/	Crimped.		_	Burrs			ons Incomplete/Unclear		Part Lost/Mi	ssing [Wrong Stock Pulled
	Cuffs				Contamination	⊢		narice	_	Part Moved		
-	Heat Trea			<u> </u>	Countersink		slabel			Positioned V		
	Inspectio		Tube		Cut Too Short	-	sread			Power Loss/	Surge [Other
	Ripples in			<u></u>	Drill Holes	\vdash	fset					
ļ	Torque W			n L	Drawing	\vdash		Calibration				
	Turning S	-			Finish	├ ─┤		equence				
	Wave/Tw	ist in Tul	be	Ī	Folio	Ou	tside	Dimensions				

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MACHINE

TO SIZE



	DESIGN	A	DRAWN BY		AEROSPACE LTD BURY, ONTARIO, CANADA	
	CHECKE	Th-	APPROVED	DRAWING NO.	SHEET	REV. A
	DATE	131	<u> </u>	TILE	SILLI	SCALE
	04.03	3.02		MOUNTING LUG		1:1
ı	. 1					

0.306

1.85 (REF)

Ø0.505 +0.005

R0.38

11

04.03.02 | NEW ISSUE - 4.450 -SYMMETRIC ABOUT C 0.273 MACHINE TO SIZE 1 R0.125 03235 R1.200 0.400

0.735

(REF)

ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005

3.700 -R0.38 (REF) 0.375 Ø0.257^{+0.005}_{0.000} (TYP) 0.750 D3235-1 MOUNTING LUG MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18986

Purchase Order Date 1/30/2013 PO Print Date 1/30/2013

Page Number 1 of 1

Order From:

VC-MET003

METEC METAL TECHNOLOGY INC. 20 TERRY FOX DRIVE PO BOX 781 VANKLEEK HILL, ON KOB 1RO

Contact Name

Vendor Phone

613 678 3957

Vendor Fax Vendor Account Nbr

613 678 3956

Buyer

Brigitte Golden

Requisition Nbr Tax Resale Nbr

Terms Currency

Net 10 CAD

10127-2607

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nbr Reference Revision ID

Description/ Mfg ID

Req Date/

Req Qty/ Taxable Unit of Measure

100.00

Each

Ship Method

Unit Price

Extended **Price**

Vendor Part Number

D3235-1P

lug

2/8/2013 Yes

Yours ppd

\$15.0500

\$1,505.00

Special Inst:

As per DWG: D3235 Rev: A

B96415

PO Total:

\$1,505.00

Change Date: 1/30/2013

No substitution or deviation without consent.

Certificate of Conformity of Material Certification required - YES NO

Change Nbr:



20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0, Canada Tel: (613) 678-3957 Fax: (613) 678-3956

Delivery Slip No.:

19135

Date:

Feb 15, 2013

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 18986	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

	¿Description		Ünit	Ordered T	Shipped quantity	Backorder
D3235-1	Mounting Lug		Each	100	100	
		Land State of the	ا المستونية	والمتواضف والمحسورة		
	,					,
			¥	İ		
				į		
		1				
			1			
IShould there is	goods must be inspected upon receipt to con e discrepancies please notify METEC within otherwise deemed accepted.	nfirm compliance. 30 days of delivery.				
Receive	d by		Thank	you for you	ır order!	

20 Terry Fox Drive, Vankleek Hill, Ontario KOB 1R0 Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont. K6A 1K7

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D3235-1

Mounting Lug

18986

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, February 15, 2013